

Date: Wednesday, 2/6/2008 10:24:15 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPAD
Job Number : 37238 -1
Estimate Number : 12784
P.O. Number :
This Issue : 2/6/2008 S.O. No. :
Prsht Rev. : NC Part Number : D35649
First Issue : 1/1 Type : SMALL /MED FAB Drawing Number : D3564 REV D
Previous Run : 36637 Material :
Due Date : 2/18/2008 Qty: 12 Um: Each
Written By :
Checked & Approved By :
Comment : Est Rev.A New Issue 07-03-08 ec
Est Rev.B As per Rev C 07-07-09 JLM
Est Rev.C As per Rev D 07-09-09 JLM Verified By:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 1.1550 sf(s)/Unit Total : 13.8600 sf(s)

M304S16GA Stainless steel sheet 0.063" thick

Batch: 106860 IB 8-2-11

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3564 ***** (D3564-1F)*****

Dwg Rev: D

Prog Rev: D

IB 8-2-11

2-Deburr if necessary

IB 8-2-11

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

508/02/12 (412)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3564 using Jigs DT 8155 and DT 8179

Form Joggle as per Dwg D3564 on brake using Jig DT 8157

508/02/12 (12) 818

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 08/02/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/6/2008 10:24:15 AM
User: Kirri Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 37238

Part Number: D35649

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP
Ensure joggle as per dwg D3429

Johnston 20 (12)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description
A/R 2059B Hardcoat
Weld hardcoat as per Dwg D3564

Batch

m/06834

FC 08/02/27 (1)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/02/27 (2)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/02/27 (1)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m/106442

FC 08/02/27 (1)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11

08-02-27

(x1)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Finishing*

08-02-27

(x1)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/27

Job Completion



W 08-02-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	37238
Description: Wearshoe		Part Number:	D3564-9
Inspection Dwg: D3564 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.225	X			
2.432	+/-0.010	2.440	X			
2.50	+/-0.030	2.50	X			
6.000	+/-0.010	6.000	X			
12.104	+/-0.010	12.104	X			
18.000	+/-0.010	18.000	X			
18.000	+/-0.010	18.000	X			
18.00	+/-0.030	18.00	X			
9.00	+/-0.030	9.00	X			
11.50	+/-0.030	11.50	X			
0.300 x 0.300	+/-0.010	301 X 301	X			
Ø0.188	+0.005/-0.001	.189	X			
R0.375	+/-0.010	.375	X			
0.063	+/-0.010	.060	X			

Measured by: B	Audited by: [Signature]	Prototype Approval:	N/A
Date: 8-2-11	Date: 08/2/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD [Signature]	[Signature]

07.09.04



NO. 37238

(REF DART MATERIAL SPEC M304S16GA)

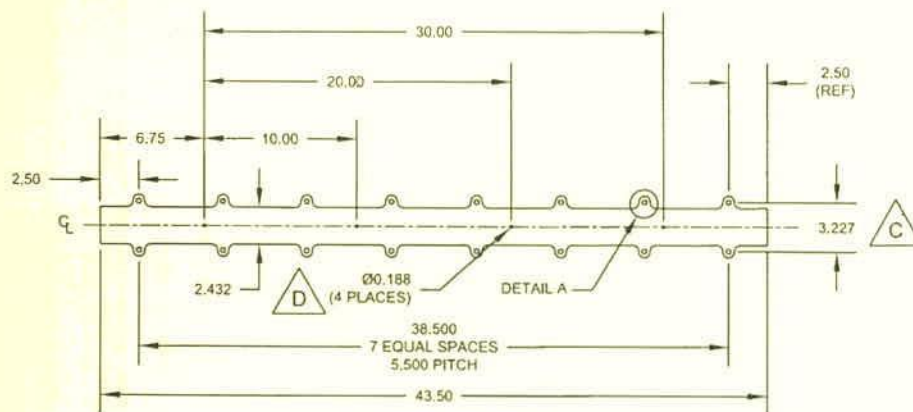
- b) SEE PG 3 FOR SECTIONS AND DETAILS
10) PARTS ARE SYMMETRIC ABOUT E

WEIGHTS

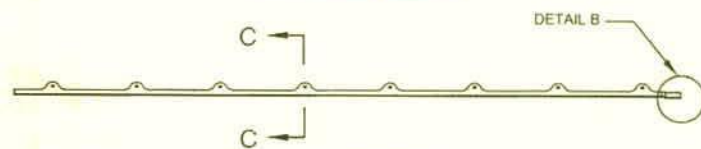
D3564-15 0.80 lbsDATE: 07 08 21

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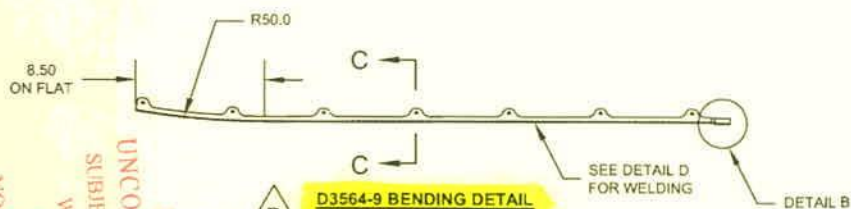
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D3564-5F FLAT PATTERN



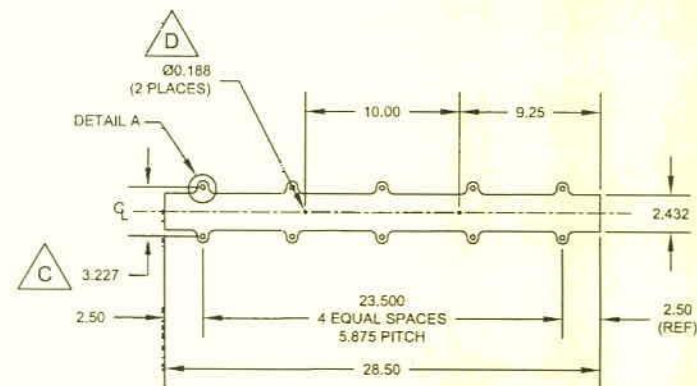
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



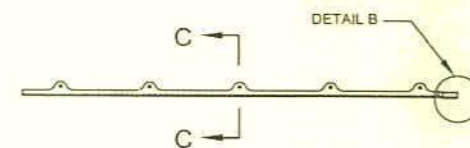
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)

SEE DETAIL D FOR WELDING

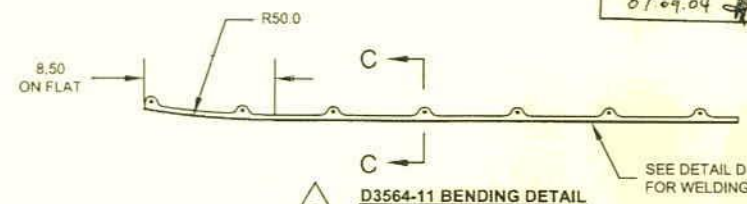
DETAIL B



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

RELEASED

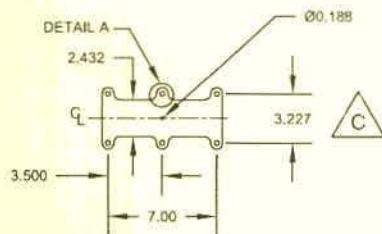
07.09.04

SEE DETAIL D FOR WELDING

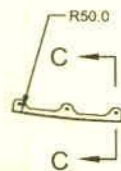
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CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
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DE APPR.	PH	WEARSHOE	1:8
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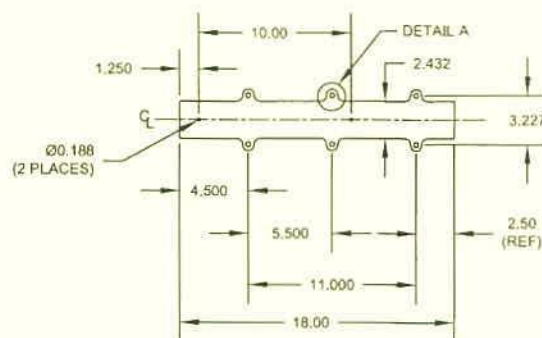
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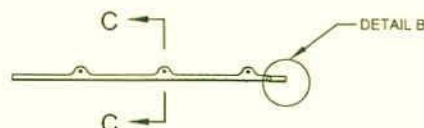
D3564-13F FLAT PATTERN



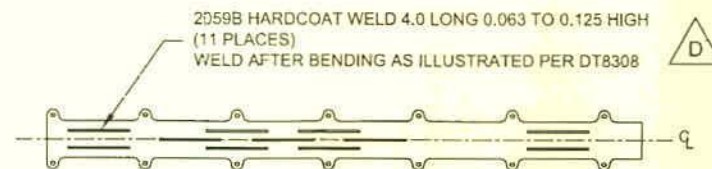
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(MAKE D3564-13 FROM D3564-13F)



D3564-15F FLAT PATTERN



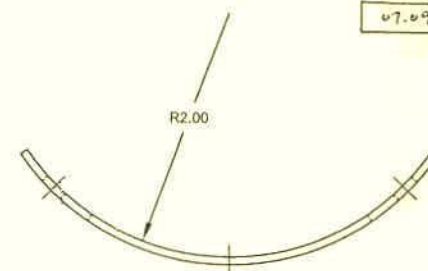
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



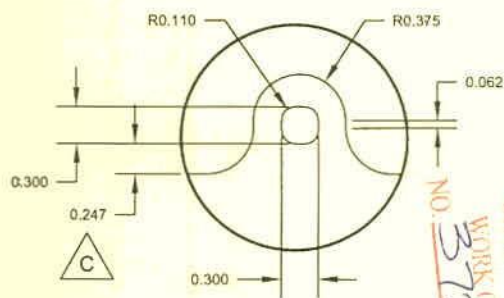
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)

RELEASED

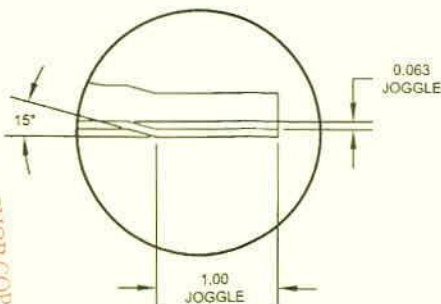
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SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

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